

Wednesday, 7/11/2007 10:42:33 AM
Simon Murdoch

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd
 Job Number : 33465 "C"
 Estimate Number : 10804
 P.O. Number : N/A
 This Issue : 7/11/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LANDING GEAR
 Previous Run : 00015

Drawing Name : D350-748-141

Part Number : D350748141
 Drawing Number : D350748141 NCR185
 Project Number : N/A
 Drawing Revision : D OK
 Material : N/A
 Due Date : 8/5/2007

Split B (PTC) →

Written By :
 Checked & Approved By :
 Material :

Qty: 1 Unit Each

Additional Product

Seq #:

Machine Or Operation:

Description :

D350748141

CROSSTUBE ASSY HIGH FWD

Comment: Qty: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

CROSSTUBE ASSY HIGH FWD

Pull D350-748-141 work orders B31902; B31903; B31904; B31905; B31906 from sequence 10.0. Continue as follows. Per NCR 185

2.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

Identify the D350-748-141 with the part number, and current batch number, in alphabetical sequence. ie: B33465-A; B33465-B,...

3.0

QC6

DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

4.0

BENDING

BENDING MACHINE

Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT

5.0

QC15

DIMENSIONAL CHECK OF X-TUBES

Comment: DIMENSIONAL CHECK OF X-TUBES

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/20	#20	W/O was split to allow B33465 "C" x-tube to be completed	En	07/08/20	x1	N/A	En 07/08/20

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-748-141

Job Number: 33165

Part Number: D350748141

Job Number



Seq. #: Machine Or Operation: Description:

50

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs.
Set-up drill table as per QSI 010

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-141

4-Remove all marks from tube within limits of D350-748-141

5- Apply a light coat of LPS3 on the interior of tube

Batch: MICHEL

Handwritten: Pencil PTO
Before drilling
tube - E/A

Handwritten: 7-7-16

Handwritten: 070716

Handwritten: S

60

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CHECK 10 DEG HOLES WITH DT8876E(EUROCOPTER CLAMP)

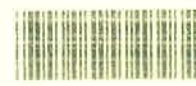
Handwritten: 7-7-17

Handwritten: (5)

60

OUTSIDE SERV.10

OUTSIDE SERVICES-LG



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 4203

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

Handwritten: 7-10-18

Handwritten: (5)

70

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

Handwritten: 7-11-18

Handwritten: 50

Handwritten: (3X)

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-748-141

Job Number: 33465

Part Number: D350748141

Job Number:



Seq. #: Machine Or Operation: Description:

10.0

QC5

INSPECT WORK TO CURRENT STEP



B33465A
B33465B
B33465C
B33465D
B33465E



Comment: INSPECT WORK TO CURRENT STEP

9/10/17 all 5 tubes

11.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Prime Outside of Tube as per Dart QSI 005 4.2

ml 07 08 18
19
20

(X5)

12.0

QC14

INSPECT SPRAY PAINT



B33465 "C"

Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

En 07/08/20 (+1)

13.0

D35021

SUPPORT



SEE NCR ON NEXT
PAGE FOR TUBE "B"



Comment: Qty: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

SUPPORT

Batch: 28476

ml 07 08 20

14.0

D2856400

Abrasion Strip



Comment: Qty: 1.2401 f(s)/Unit Total: 6.2003 f(s)

Abrasion Strip 7.10" long x2

Batch: 32020

ml 07 08 20

15.0

ALS41032225

Insert



Comment: Qty: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Insert

Batch: 19393

ml 07 08 20

16.0

AN950JD10

Washer



Comment: Qty: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Washer

Batch: 100151

ml 07 08 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	City	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.07.12	4.0	Tube - E is higher on one side by 0.125" Tube - A also is 125 higher on side B though	<i>[Signature]</i> QS1042	Cut as manufactured on tube and the well side of the cut line to make both sides even on the height	<i>[Signature]</i> 07.07.13 J. G. [unclear]	<i>[Signature]</i> QS1042	<i>[Signature]</i> 07.07.12	
07.07.13	6.0	HOLES FOR SHOCK ABSORBERS ARE SHIFTED BY APPROX. 0.100". 24.61" DIA IS 24.72" & 24.72". TWICE "B"	<i>[Signature]</i> 07.07.13 per QS1042	CENTER THE D352-1 SUPPORTS BETWEEN THE HOLES (i.e. SHIFT BY 0.100"). REF DS EMAIL ATTACHED		<i>[Signature]</i> 07.07.13 per QS1042	<i>[Signature]</i> 07.07.13	

NOTE: Date & initial all entries.

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-748-141

Job Number: 33465

Part Number: D350748141

Job Number



Seq. #:

Machine Or Operation:

Description:

17.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 104902

ml 07.08.20

18.0

MS27039110

Screw



Comment: Qty: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Screw

Batch: 18856

ml 07.08.20

19.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using DI8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

ml 07.08.20

20.0

QCS

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

333465 "C"
Er 07.08.20

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-241

Location: _____

PPP Rev: _____

C2671081200

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

A 07.08.20
V 07.08.20

At Completion



USED IN B31902.

DART

RELEASED

06.10.31

DESIGN	QD	DRAWN BY	QD	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE	06.10.31			TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
A	06.03.31			NEW ISSUE	
B	06.06.30			ADD D6017-115 & PRIME AND PAINT	
C	06.08.14			ADD CAD PLATING	
D	06.10.31			MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125
FINISHED LENGTH = 110.27±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY. TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

UNDER REVIEW

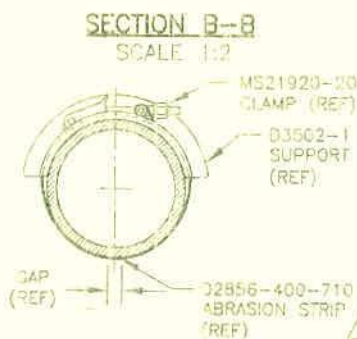
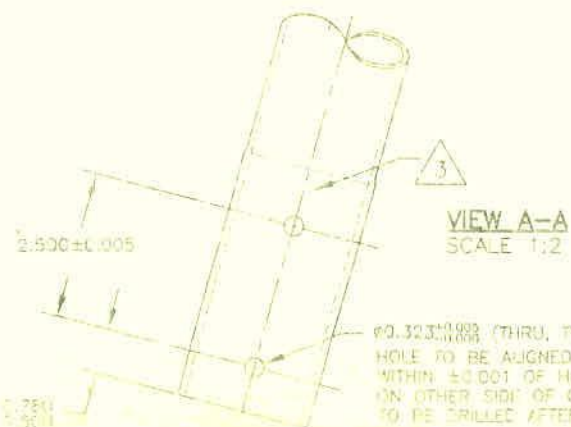
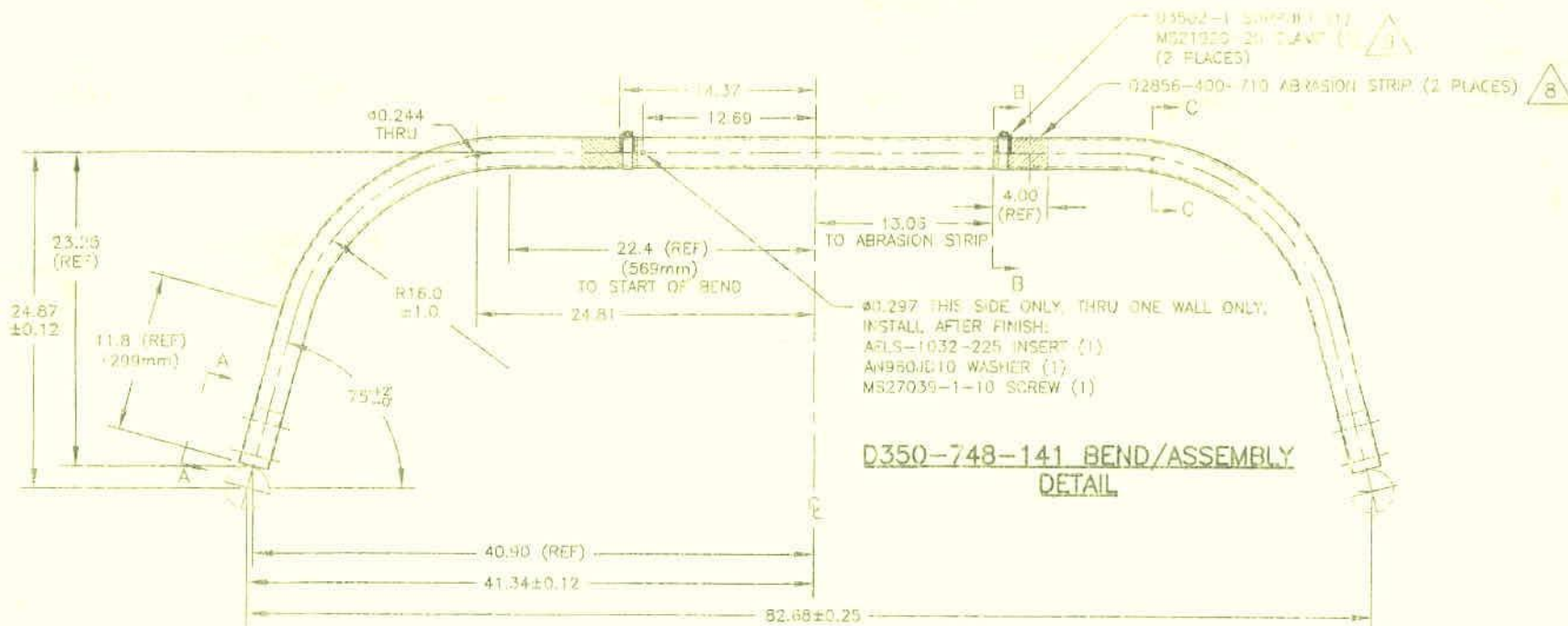
07.07.16

CUT BOLD REMOVED

OK

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UNDER REVIEW
07.21.01
RELEASED
08.14.01

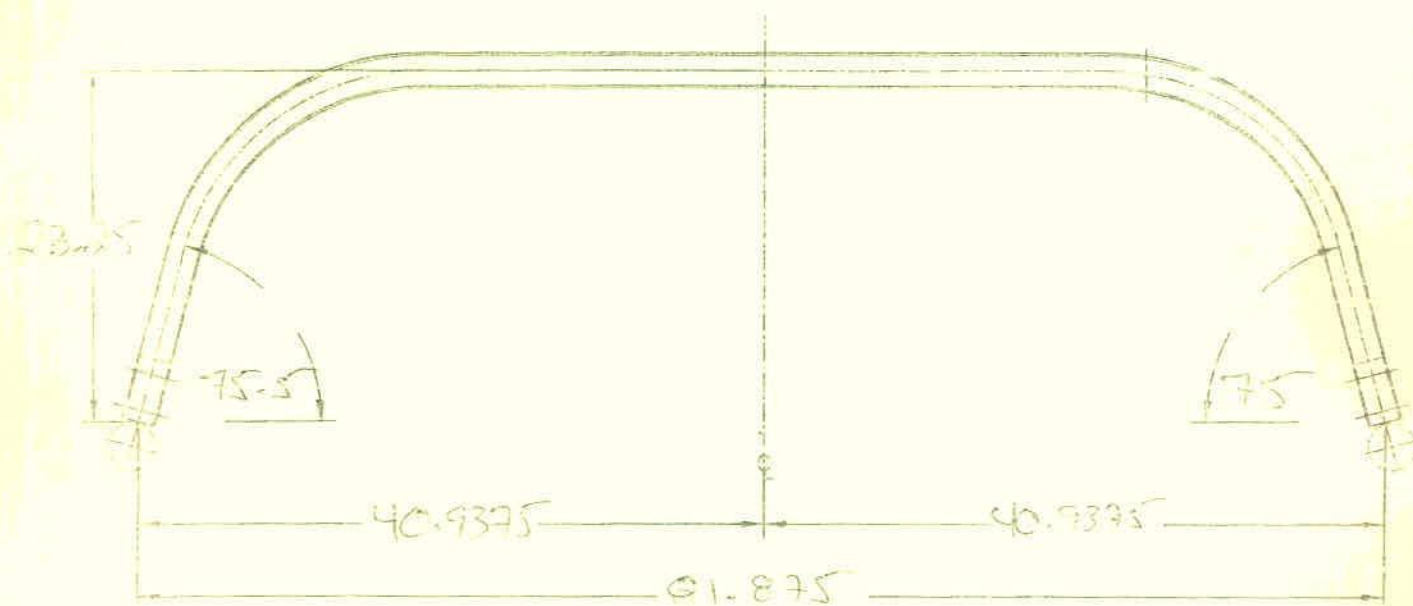
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DESIGN	92	DESIGN BY	92	DART	DART AEROSPACE LTD. WIMBORNETH, OXFORD, OX5 1GB	REV. D
CHECKED	1	APPROVED	1	DRAWING NO.	D350-748-141	SHEET 2 OF 3
DATE	06.10.01	TITLE	CROSSTUBE (AS 350/355 HI TWD)	SCALE	1:8	

DART AEROSPACE LTD		Work Order:	33465-C
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments

QC15 Inspection	<i>[Signature]</i>
Date	2007.12

Rev	Date	Change	Revised by	Approved
1	07.02.06	New Issue	KJ/JM	

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: July 12, 2007 12:39 PM
To: 'Chris Provencal'
Cc: 'Marc Bellavance'
Subject: FW: NCR D350-748-141
Attachments: ncrD350748141.jpg

I don't think this is a problem.
However, looking at the sketch you provided, my preference would be to shift the center over by 0.125 so that the shock absorbers are centered.
That way, you would be out by 0.125" at the ground rather than at the supports.
Make sense?

Davie

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Thursday, July 12, 2007 9:29 AM
To: 'David Shepherd (*David Shepherd)'
Cc: 'Marc Bellavance'
Subject: NCR D350-748-141

Davie,

Qty(1) D350-748-141, the holes for the shock absorbers have been shifted by about 0.125" (see attached). They think the jig moved while they were working on it. The shock absorbers will still fit since they can have a single-bolt attachment to the clamps and can pivot. Our tubes survived drop testing without the shock absorbers, so this should not affect the strength of our tubes. This may affect the g-loading / load transfer into the fuselage, but 1/8" is unlikely to be significant.

Is this acceptable?

Chris

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.476 / Virus Database: 269.10.4/897 - Release Date: 7/11/2007 9:57 PM

No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.476 / Virus Database: 269.10.4/897 - Release Date: 7/11/2007 9:57 PM

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Aug-13-2007

CONSIGNEE TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 68797
INVOICE #: 35484

**CONTRACT OR
PURCHASE ORDER #** 4203

DESCRIPTION: SKID

QTY 5

P/N # D350748141

S/N # B33465

**CADMIUM PLATE IAW AMS-QQ-P-416 TYPE 2 CLASS 1.MPI IAW
ASTM-E-1444. AND ACCEPTED BAKE HEAT CHARTS#8066 & 8136**

CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.

Approved Inspector:



R. LAST

Tuesday, 4/17/2007 3:52:20 PM

V Johnston

Process Sheet

: CU-DAR001 Dart Helicopters Services		Drawing Name	: X-TUBE AS 350/355 HI FWD UNDER REVIEW	
: 31906A				
: 12484				
: 4/17/2007 S.O. No. :		Part Number	: D350748141	
: NC		Drawing Number	: D350-748-141 WAR	
: 1/1 Type : LANDING GEAR		Project Number	: N/A	
: 31905A		Drawing Revision	: ED OK 07.04.18	
		Material		
		Due Date	: 5/30/2007	Qty: 1 Um: Each
Id By	: <u>07.04.18</u>			
	: Est Rev: A New Issue 06-07-05 JLM			
	: Est Rev: B Update cadplate process 06-09-12 KJ			



Machine Or Operation:

Description :

DC

DOCUMENT CONTROL



: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D350-748-141 CHG001

S.F. 07/01/21

D6017115

Crosstube Material



Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Material

D6017-115

2.339" OD X 2.000" ID

Batch: B27471

S.F. 07/04/21

ORI SEIKI

MORI SEIKI CNC LATHE LARGE



MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA648

2-Turn first side as per Folio FA648

1-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-141.

S.F. 07/01/21

1

INSPECT ALL DIM TO DIM SHEET



INSPECT ALL DIM TO DIM SHEET

S.F. 07/04/21

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\INCRWO RevD

Date: Tuesday, 4/17/2007 3:51:42 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-TUBE AS 350/355 HI FWD UNDER REVIEW
Job Number	: 31905A		
Estimate Number	: 12484		
P.O. Number	:	Part Number	: D350748141
This Issue	: 4/17/2007 S.O. No. :	Drawing Number	: D350-748-141 CHG
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : LANDING GEAR	Drawing Revision	: 8D OK 07.04.18
Previous Run	: 31904A	Material	:
Written By	:	Due Date	: 5/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.04.18</u>		
Comment	: Est Rev: A New Issue 06-07-05 JLM Est Rev: B Update cadplate process 06-09-12 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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SRE W10 33465



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D350-748-141 CHG001

S.B 07/04/21

2.0	D6017115	Crosstube Material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Material

D6017-115

2.339" OD X 2.000" ID

Batch: B27471

S.E 07/04/21

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA648

2-Turn first side as per Folio FA648

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-141.

S.E 07/04/21

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

S.B 07/04/21

Date: Tuesday, 4/17/2007 3:51:03 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : X-TUBE AS 350/355 HI FWD UNDER REVIEW
Job Number : 31904A	
Estimate Number : 12484	
P.O. Number : <i>N/A</i>	Part Number : D350748141
This Issue : 4/17/2007 S.O. No. : <i>N/A</i>	Drawing Number : D350-748-141 <i>OK</i>
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : <i>ED</i>
Previous Run : 31903A	Material : <i>N/A</i>
Written By : <i>John 04.18</i>	Due Date : 5/30/2007 Qty: 1 Um: Each
Checked & Approved By : <i>John 04.18</i>	
Comment : Est Rev: A New Issue 06-07-05 JLM	
Est Rev: B Update cadplate process 06-09-12 KJ	

Additional Product

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D350-748-141 CHG001 <i>SEE WIO 33465</i>		
2.0	D6017115	Crosstube Material
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Crosstube Material D6017-115 2.339" OD X 2.000" ID Batch: <i>B27241</i>		
3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
Comment: MORI SEIKI CNC LATHE LARGE 1-Fill tube with sand & install plugs on both ends as per Folio FA648 2-Turn first side as per Folio FA648 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-141.		
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
Comment: INSPECT ALL DIM TO DIM SHEET		

Date

Wednesday, 4/17/2007 3:50:21 PM
Kim Johnston

Dart Aerospace Ltd.

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 31903A
Estimate Number : 12484
P.O. Number :
This Issue : 4/17/2007 S.O. No. :
Revised Rev. : NC
First Issue : 1/1 Type : LANDING GEAR
Previous Run : 31902A

Drawing Name : X-TUBE AS 350/355 HI FWD UNDER REVIEW
Part Number : D350748141
Drawing Number : D350-748-141
Project Number : N/A
Drawing Revision : *AD*
Material :
Due Date : 5/30/2007
Qty: 1 Um: Each

Written By :
Checked & Approved By : *[Signature]*
Comment :
Est Rev: A New Issue 06-07-05 JLM
Est Rev: B Update cadplate process 06-09-12 KJ

Additional Product

Part Number:


Seq. #: Machine Or Operation: Description :
1.0 DC DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile and create labels as per PPP D350-748-141 CHG001
2.0 D6017115 Crosstube Material

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Crosstube Material
D6017-115
2.339" OD X 2.000" ID
Batch: *27471*

MORI SEIKI MORI SEIKI CNC LATHE LARGE
Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA648
2-Turn first side as per Folio FA648
3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-141.
INSPECT ALL DIM TO DIM SHEET

INSPECT ALL DIM TO DIM SHEET

NOTE: Date & Initial at
H:\FORMS\Quality Assurance\approved QAINCRWO RevD

SEEK N10 33465

8.5 07/04/28

8.8 07/04/22

8.8 07/04/22

8.8 07/04/22

Date: Tuesday, 4/17/2007 3:49:42 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : X-TUBE AS 350/355 HI FWD UNDER REVIEW
 Job Number : 31902A
 Estimate Number : 12484
 P.O. Number :
 This Issue : 4/17/2007 S.O. No. :
 Part Number : D350748141
 Drawing Number : D350-748-141 ~~UHR~~
 Prsht Rev. : NC Project Number : N/A
 First Issue : 1/1 Type : LANDING GEAR Drawing Revision : ~~8D~~ OK 4/20/08
 Previous Run : 31901A Material :
 Due Date : 5/30/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : *John A. 18*
 Comment : Est Rev: A New Issue 06-07-05 JLM
 Est Rev: B Update cadplate process 06-09-12 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Spec w/10 33465



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D350-748-141 CHG001

SB 07/04/22

2.0 D6017115 Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Material

D6017-115

2.339" OD X 2.000" ID

Batch: *27471*

BC 07.04.20 (1)

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA648

2-Turn first side as per Folio FA648

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-141.

SB 07/04/22

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SB 07/04/22

